Select 410NiMo

Description:

Select 410NiMo is a gas-shielded, flux cored, stainless steel electrode designed for single or multipass welding in the flat and horizontal positions. It has a nominal weld metal composition of 12% Cr, 4.5% Ni, 0.6% Mo and a maximum carbon content of 0.06%. It deposits a low carbon, martensitic stainless steel. It is designed for use with 100% carbon dioxide.

Classifications:

- E410NiMoT0-1 per AWS A5.22

Characteristics:

Select 410NiMo provides superb performance characteristics using CO_2 shielding gas. It has a smooth, stable arc, low spatter residue, easy slag peeling and produces smooth, well-washed beads.

Applications:

Select 410NiMo finds wide application in power generation equipment, such as turbine blades and vanes. It is widely used to weld ASTM CA6NM castings as well as 410, 410S and 405 stainless steels.

Typical Mechanical Properties(CO_2):

	SR 1 Hr. at 1125° F
Ultimate Tensile Strength (psi)	128,000
Yield Strength (psi)	107,000
Percent Elongation	17

Typical Weld DepositChemistry (CO_2):

Shielding Gas	C	Mo	Cr	Mn	Ni	Si
100CO_2	.03	0.60	12.20	.70	4.70	.50

Typical Welding Parameters (CO_2):

	Optimum			Range	
Diameter	Amperage	WFS	Voltage	Amperage	Voltage
3/32"	425	180	29	300-550	26/34
1/16"	330	330	29	150-400	22-34
.045”	250	450	28	130-300	21-32

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